

Work Order ID 57249

March 31, 2010 10:03:29 AM



Page 1

Item ID: D5953

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, 205

Start Date: 31/03/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 09/04/2010 Req'd Qty: 6.00

Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date: 10-3-31

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D5953

Rev B

100



HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

0.00

H.A 10/04/10

6 0

Memo

0.00

1-Machine as per folio D5953, Ensure Batch Number is entered
Keyway 3-Deburr & Tumble

110



QC

Quality Control

QC1- Inspect dimensions to dimension sheet

0.00

H.A 10/04/10

6 0

Memo

0.00

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

MMU-
10/04/11

6 0

Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 57249

March 31, 2010 10:03:29 AM



Page 2

Item ID: D5953

Revision ID:

Item Name: Saddle, 205

Start Date: 31/03/2010 Start Qty: 6.00

Required Date: 09/04/2010 Req'd Qty: 6.00

Reference:

Accept



Setup Start

Stop

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00

BR 10-4-13

6 1

HandFinish

Memo

0.00

Hand Finishing

140

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

M114207

Memo

0.00

Powdercoat

Powder Coating

START TIME:

12:45p

OVEN TEMPERATURE:

1:15pm FINISH TIME:

320°F

150

QC3- Inspect Part Finish

0.00

BR 10-4-13

6

QC

Quality Control

Memo

0.00

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 57249

March 31, 2010 10:03:29 AM



Page 3

Item ID: D5953

Revision ID:

Item Name: Saddle, 205

Start Date: 31/03/2010 Start Qty: 6.00

Required Date: 09/04/2010 Req'd Qty: 6.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



Packaging

Identify as per dwg & Stock Location: 430

0.00

Memo

0.00

10/4/04 (6)

170



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/04/15 (6)

10-4-14 (6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March 31, 2010 10:03:33 AM

Page 1

Work Order ID: 57249

Parent Item: D5953

Parent Item Name: Saddle, 205


Comments: IPP Rev:E Re-Format 05-11-29 JLM
IPP Rev:f ecn 826 06.12.06 EC

Start Date: 31/03/2010

Required Date: 09/04/2010

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6101-007		Manufactured	No			100	Each	58.0000	6.0000			
												
Saddle Billet												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
MAT42	58	
41960	1	
46412 ✓	57	

6

H.A 10/04/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 57249
Description: Inner Fwd Saddle		Part Number: D5953
Inspection Dwg: D5953	Rev: B	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		0.440	0.440	0.440	0.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	5.245	5.255		5.250	5.250	5.250	5.250		
D	6.995	7.005		7.000	7.000	7.000	7.000		
E	5.240	5.260		5.250	5.250	5.250	5.250		
F	4.745	4.755		4.750	4.750	4.750	4.750		
G	0.315	0.322		0.321	0.321	0.321	0.321		
H	1.522	1.532		1.527	1.527	1.527	1.527		
I	3.048	3.058		3.053	3.053	3.053	3.053		
J	4.575	4.585		4.580	4.580	4.580	4.580		
K	0.315	0.322		0.321	0.321	0.321	0.321		
L	0.495	0.505		0.500	0.500	0.500	0.500		
M	0.490	0.510		0.501	0.502	0.502	0.502		
N	1.615	1.635		1.626	1.626	1.626	1.626		
O	7.990	8.010		8.000	8.000	8.000	8.000		
P	2.240	2.260		2.250	2.250	2.250	2.251		
Q	0.307	0.312		0.310	0.310	0.310	0.311		
R	0.760	0.765		0.764	0.763	0.763	0.763		
S	0.490	0.510		0.497	0.499	0.500	0.500		
T	1.375	1.395		1.386	1.386	1.386	1.385		
U	2.000	2.020		2.004	2.004	2.004	2.004		
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: A.A
Date: 10/04/10

Audited by: MMJ
Date: 10/04/11

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF	
C	06.12.06	Dimensions L,N,P revised	KJ/EC	
D	07.06.15	Dimension G revised	KJ/JLM	
E	08.04.21	Dimension E revised	KJ/DD	
F	08.12.01	Dimension K revised	KJ/DD	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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DART AEROSPACE LTD		Work Order: 57249
Description: Inner Fwd Saddle		Part Number: D5953
Inspection Dwg: D5953	Rev: B	Page 2 of 2

Inspect dimensions highlighted on inspection sheet drawing and record below:

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				15	26	8	1		
A	0.438	0.443		0.440	0.440				
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C	5.245	5.255		5.250	5.250				
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F	4.745	4.755		4.750	4.750				
G	0.315	0.322		0.321	0.321				
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K	0.315	0.322		0.321	0.321				
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N	1.615	1.635		1.626	1.626				
O	7.990	8.010		8.000	8.000				
P	2.240	2.260		2.250	2.250				
Q	0.307	0.312		0.310	0.310				
R	0.760	0.765		0.763	0.763				
S	0.490	0.510		0.500	0.500				
T	1.375	1.395		1.386	1.386				
U	2.000	2.020		2.004	2.004				
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: <i>MA</i>	Audited by: <i>MJE</i>
Date: 10/04/10	Date: 10/04/11

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF	
C	06.12.06	Dimensions L,N,P revised	KJ/EC	
D	07.06.15	Dimension G revised	KJ/JLM	
E	08.04.21	Dimension E revised	KJ/DD	
F	08.12.01	Dimension K revised	KJ/DD	

5014
1286

SHOT COPY
RETURN TO
ENGINEERING
UNCONTROLLED
SUBJECT TO

WITHOUT NOTICE
WORK ORDER

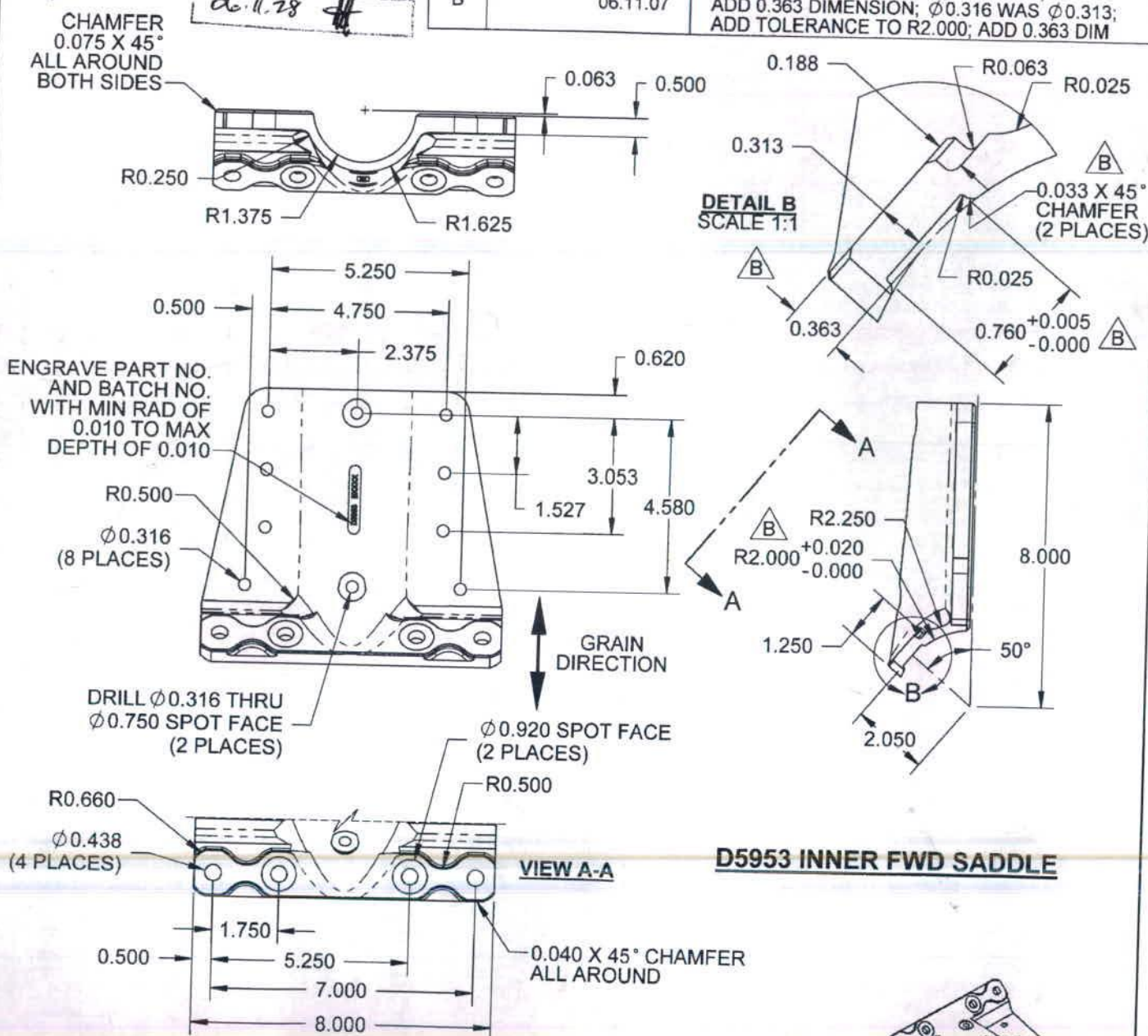
DART

NO. 57249

PJ10-3-31

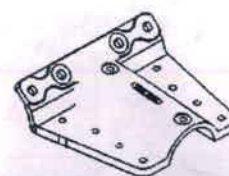
06.11.28

DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED H	DRAWING NO. D5953	REV. B SHEET 1 OF 1
DATE 06.11.07	TITLE INNER FWD SADDLE		
REV A	DATE 97.05.06	DESCRIPTION NEW ISSUE	
B	06.11.07	INCORPORATE DEO 9102, DEO 9079; ADD 0.363 DIMENSION; $\phi 0.316$ WAS $\phi 0.313$; ADD TOLERANCE TO R2.000; ADD 0.363 DIM	



NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 PER QQ-A-250/12
(MAKE FROM D6101-007 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020



ISOMETRIC VIEW
SCALE 1:8

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